

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62059

Wednesday, September 15, 2010 1:49:01 PM



Page 2

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 9/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

2L 10/11/11



QC

Memo

0.00

Quality Control

6

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> 10/11/11



HandFinish

Memo

0.00

Hand Finishing

6 8

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:30 OVEN TEMPERATURE:
3:20 FINISH TIME: 9:00

6 10-11-12

W/O:		WORK ORDER CHANGES					
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Work Order ID 62059

Wednesday, September 15, 2010 1:49:01 PM

Page 3

Item ID: D2938-1

Accept

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 9/15/2010 Start Qty: 6.00

Required Date: 9/22/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 11 12 (6)

170

Identify as per dwg & Stock Location 428A

0.00



Packaging

Memo

0.00

Packaging

LC 10/11/12 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15 (4)

BS 10-11-12 (4)

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Picklist Print

Wednesday, September 15, 2010 1:49:06 PM

Page 1

Work Order ID: 62059



Parent Item: D2938-1



Parent Item Name: Saddle LH Out, 206

Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	43.0000	1	6			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT042

43

59196

3

61250

40

6.0

N.A 10/11/10

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62059
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.121	0.120	0.118	Mic	N8-120
B	0.100	0.140		0.119	0.119	0.120	0.119	"	"
C	0.100	0.140		0.121	0.121	0.123	0.122	"	"
D	0.210	0.230		0.223	0.223	0.223	0.223	Vern	6A-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		0.510	0.510	0.510	0.510	"	"
I	1.572	1.582		1.577	1.577	1.577	1.577	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		0.260	0.260	0.260	0.260	"	"
L	0.312	0.317		0.316	0.316	0.316	0.316	"	"
M	0.235	0.240		0.237	0.237	0.237	0.237	"	"
N	0.100	0.140		0.115	0.115	0.115	0.115	Mic	6A-03
O	0.540	0.560		0.549	0.549	0.549	0.549	Vern	6A-01
P	0.490	0.510		0.502	0.502	0.502	0.502	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.720	2.760		2.740	2.740	2.740	2.740	"	"
S	0.240	0.270		0.253	0.253	0.253	0.253	"	"
T	0.100	0.180		0.130	0.130	0.130	0.130	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.367	1.367	1.367	1.367	"	"
W	0.316	0.321		0.317	0.317	0.317	0.317	"	"
X	1.250	1.270		1.2548	1.2588	1.2597	1.2596	Dial	HAASZ
Y	1.565	1.585		1.5732	1.5728	1.5725	1.5728	"	"
Z	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	M.A
Date:	10/11/10

Audited by:	JL
Date:	10/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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DART AEROSPACE LTD	Work Order: 62059
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

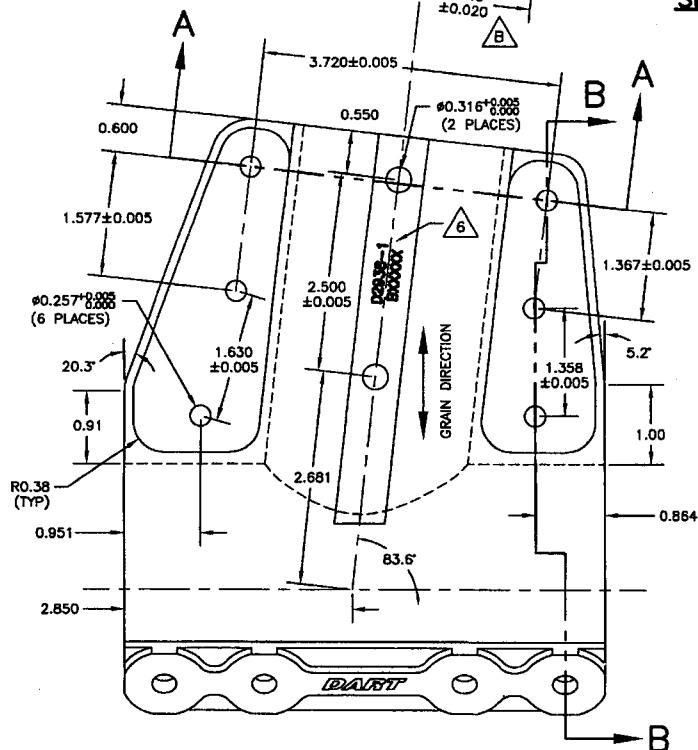
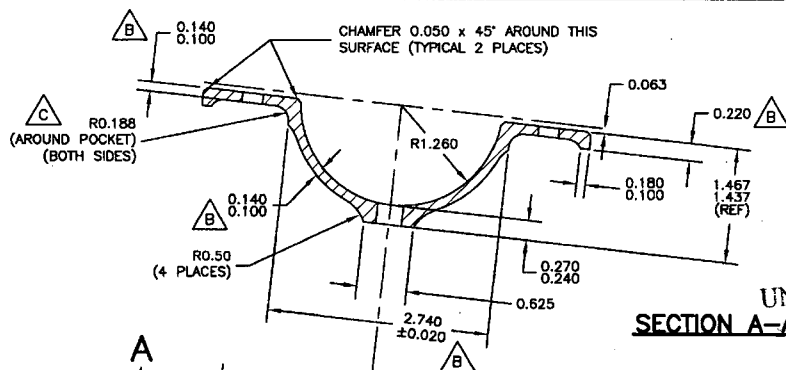
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	18	19	By	Date
A	0.100	0.140		0.121	0.120				
B	0.100	0.140		0.119	0.118				
C	0.100	0.140		0.122	0.123				
D	0.210	0.230		0.223	0.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.260	0.260				
L	0.312	0.317		0.316	0.316				
M	0.235	0.240		0.237	0.237				
N	0.100	0.140		0.115	0.115				
O	0.540	0.560		0.549	0.549				
P	0.490	0.510		0.500	0.501				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		0.253	0.253				
T	0.100	0.180		0.130	0.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.317	0.317				
X	1.250	1.270		1.2595	1.2597				
Y	1.565	1.585		1.5730	1.5728				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: H.A
Date: 10/11/10

Audited by: SL
Date: 10/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

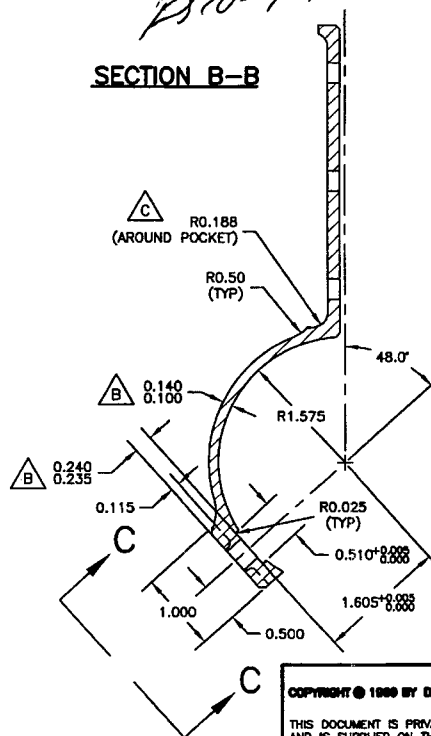


SHOW
RETURN
ENGINEER
UNCONTROLLED

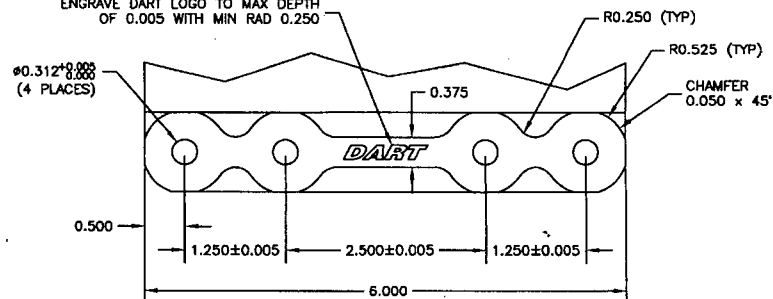
SECTION A-A

NO. 42059
28-0-9-13

SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2938

REV. C
SHEET 1 OF 1

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